

Work Order ID 85977

85977

Page 1

June-19-12 12:00:02 PM

Item ID: D2278

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Step Leg

Stop ***NS2***

Start Date: 19/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2278	Rev F								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2278 Dwg Rev: F Prog Rev: F 2-
Deburr if necessary

12 0 Jm 12-6-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 0 Jm 12-6-23

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12 0 M 12 08 24

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

12 NG 12-6-25

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

12x 12/07/11

150

Identify as per dwg & Stock Location

0.00

150

Packaging

Memo

0.00

Packaging

12x 12/07/11

Dart Aerospace Ltd

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

CK 12/2/12

R120711

Dart Aerospace Ltd

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Picklist Print

June-19-12 12:00:05 PM

Page 1

Work Order ID: 85977

85977

Parent Item: D2278

D2278

Parent Item Name: Step Leg

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
 IPP Rev:B Now 6061-T6 06-06-23 JLM
 IPP Rev C New flat pattern 08.01.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080		Purchased	No			100	sf	334.5443	0.9815	12.39789			
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M6061T6S 080

6061-T6 .080 Sheet

**

Jm 12-6-23

Location

Loc Qty

Loc Code

MAT021

334.544316

117285

0.124316

119766

39.6

120096

281.12

121193

13.7

120096

Dart Aerospace Ltd

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
05977 MJS

12/10/19

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/11 OR AMS 4025/4027)
(REF DART SPEC M6061T6S.080)
OR
5052-H32 ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/8 OR AMS 4016)
(REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

D2278 LEG

RELEASED
01-10-19

F	CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 SLOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT, REF NCR 263	PH	07.12.27
E	ADD 6061-T6 MATERIAL	CB	06.05.29
D	ADD FINISHING NOTE	PH	05.11.14
C	CHANGED RADIUS TO 0.354	BW	95.02.16
B	CHANGED TO MATCH SPACERS	BW	94.11.08
A	NEW ISSUE	BW	94.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RA		
DRAWN	RA		
CHECKED	KE		
MFG. APPR.	KE		
APPROVED	KE		
DE APPR.	KE		
DATE	07.12.27		
<div>DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA</div> <div><div>DRAWING NO. D2278</div><div>TITLE LEG</div></div> <div><div>REV. SHEET 1 OF 1</div><div>SCALE 3:2</div></div> <div><div>COPYRIGHT © 1995 BY DART AEROSPACE LTD</div><div><small>THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. NO IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small></div></div>			

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